

Work Order ID 116181

Monday, April 07, 2014 2:05:53 PM

116181

Page 1

Item ID: D4785-117

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rib Assembly

Stop ***NS2***

Start Date: 4/7/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/7/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MF Date: 14-4-7

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4785

B

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9922

2x CC 14-4-7

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

107

Weld per dwg A/R S.S. rod Batch: B123823

0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D4785
2- grind welds flush2x CC 14-4-9

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Page 2

Setup Start *NS1*

Stop *NS2*

Customer:

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NB2***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

0.00

Quality Control

PTO \rightarrow

0.00

0.00

Quality Control

Identify as per dwg & Stock Location:_____ 0.00

0.00

Packaging

Packaging

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Jul Date: 14/5/1QA Closed: JA Date: 14-5-1

Work Order: <u>116181</u> Part No. <u>D4785-117</u> NCR No. <u>14-3803</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input checked="" type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
----------------------------------------------------------------------------------	--	--	--	----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--	----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	--	--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input checked="" type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>	<u>14/04/09</u>	<u>100</u>	<u>2</u>	welder installed wrong bushing (used D3759-1 110097 instead of D4021-9) welder skip QC6 and welded Rk. lack of attention	DAS 16 9-89 Q72042 14/04/09	Scrap & destroy D4306-1 B103563 2' D3759-1 B110097 4' \$79.75 \$4.25 \$83.00	CC 14-4-9	DAS 9 9-89 14/4/9	DAS 27 9-89 14/4/9

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input checked="" type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Quality Control

14-4-16

Picklist Print

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Page 1

Work Order ID: 116181

116181

Parent Item: D4785-117

D4785-117

Parent Item Name: Rib Assembly

Start Date: 4/7/2014

Required Date: 4/7/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.06.21 DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No				Each	98.0000		4			

D4021-9

Bushing

Location

Loc Qty

Loc Code

WA004

98

~~B113905~~

107634

90

B110057

113905

8

Each

1.0000

2

D4306-1

Manufactured

No

D4306-1

Rib

Location

Loc Qty

Loc Code

WA004

1

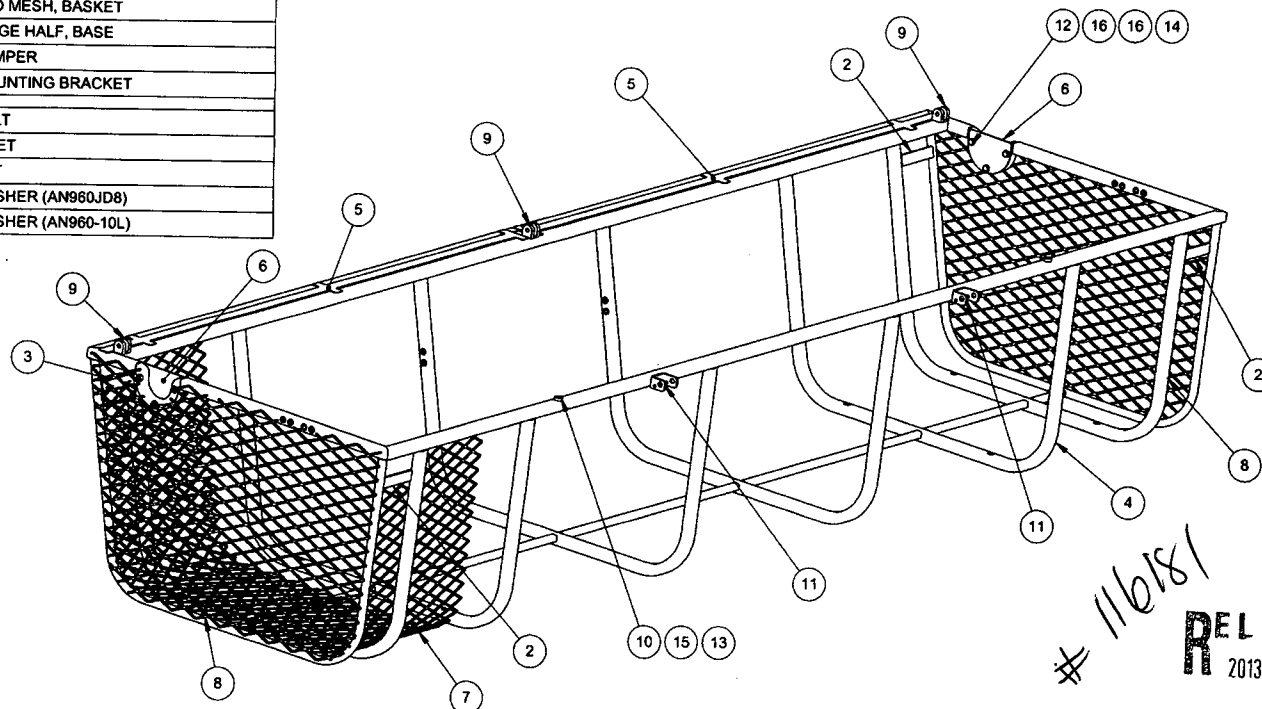
103563

1

~~2x~~

CC 14-4-7

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)



D4785-041 LONG BASKET BASE ASSY, LH/RH 

NOTES:

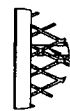
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO. D4785 REV. B	
CHECKED	<i>SC</i>	SHEET 1 OF 7	
MFG. APPR.	<i>IS</i>	TITLE LONG BASKET BASE ASSY SCALE NTS	
APPROVED	<i>SC</i>	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
DE APPR.	<i>SC</i>	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.06.11		

RELEASED
2013-06-20

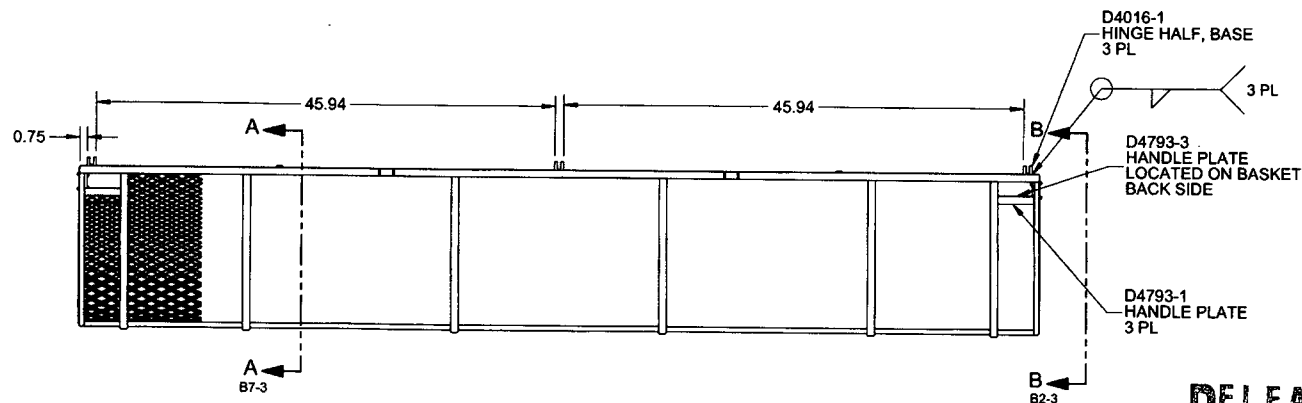
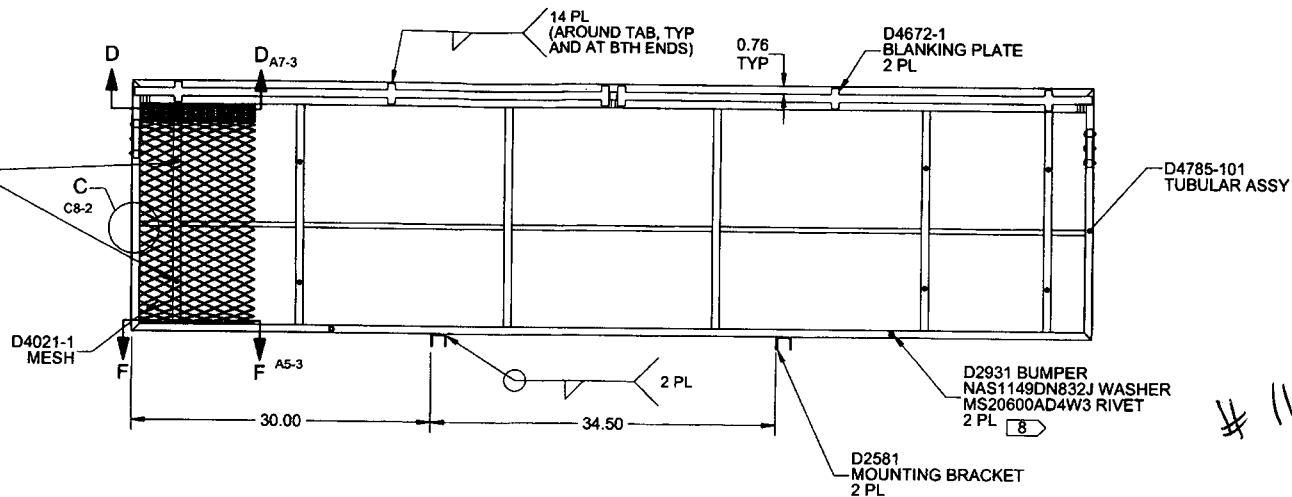
TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP

D4021-1
MESH



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
R 2013-06-20

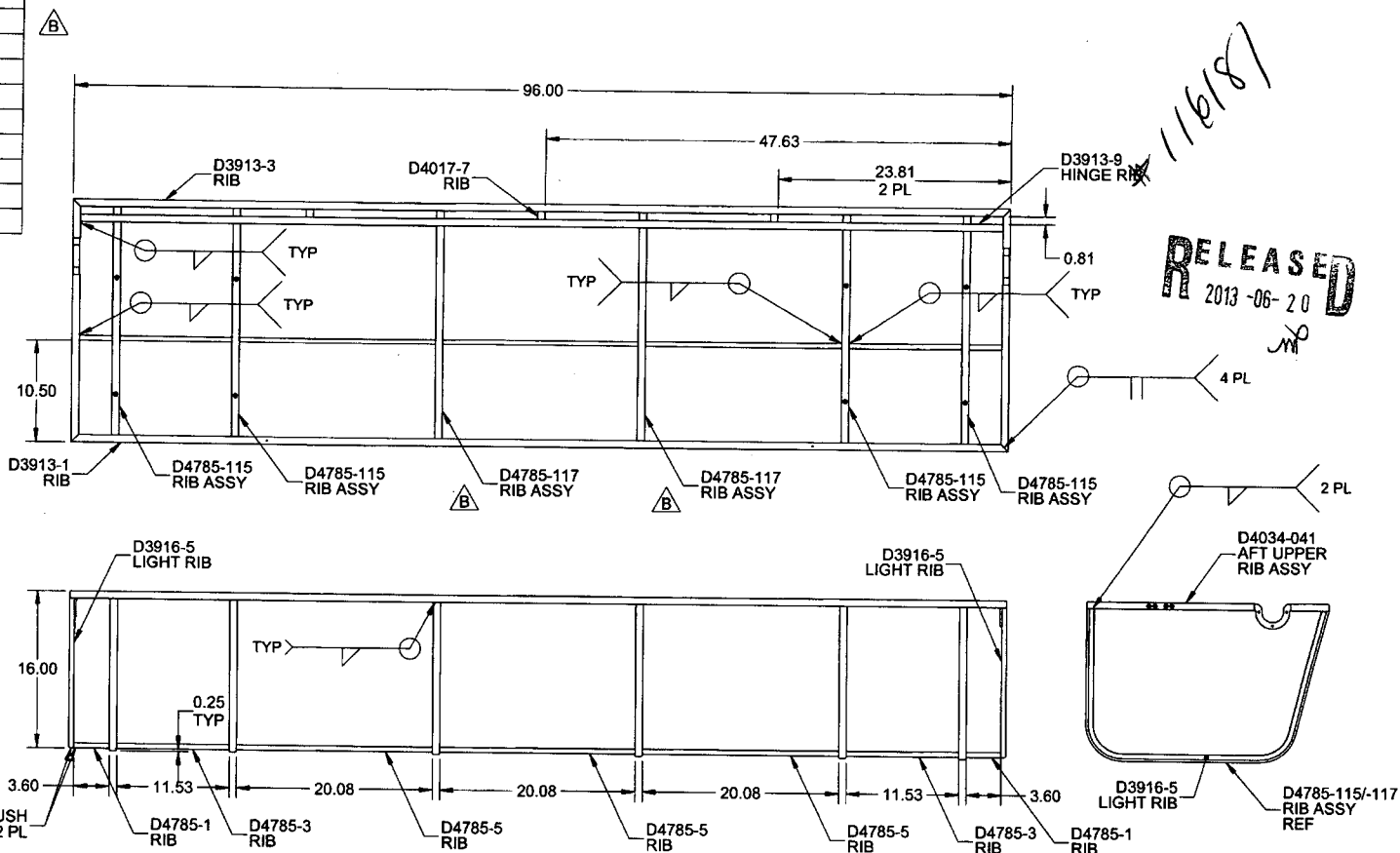
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	IN	D4785	SHEET 2 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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RELEASE
2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	D4785	SHEET 3 OF 3
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -101	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB



NOTES:

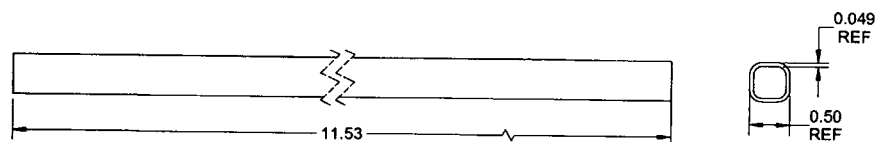
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.65 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

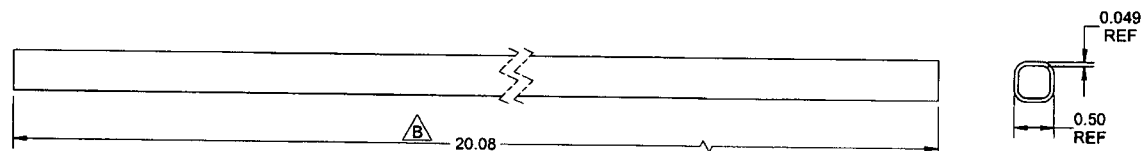
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DRAWN	RF		
CHECKED	DE	DRAWING NO.	REV. B
MFG. APPR.	DE	D4785	SHEET 4 OF 7
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	LONG BASKET BASE ASSY	NTS
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D4785-1 RIB



D4785-3 RIB



D4785-5 RIB

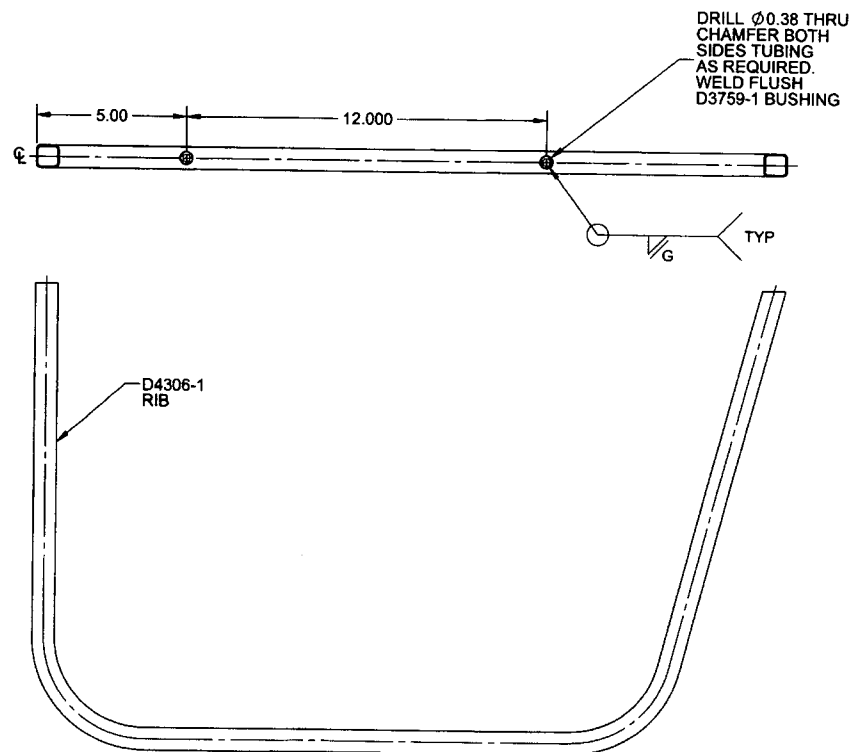
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	#	D4785	SHEET 5 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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RELEASED
2013-06-20
NT

ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

NOTES:

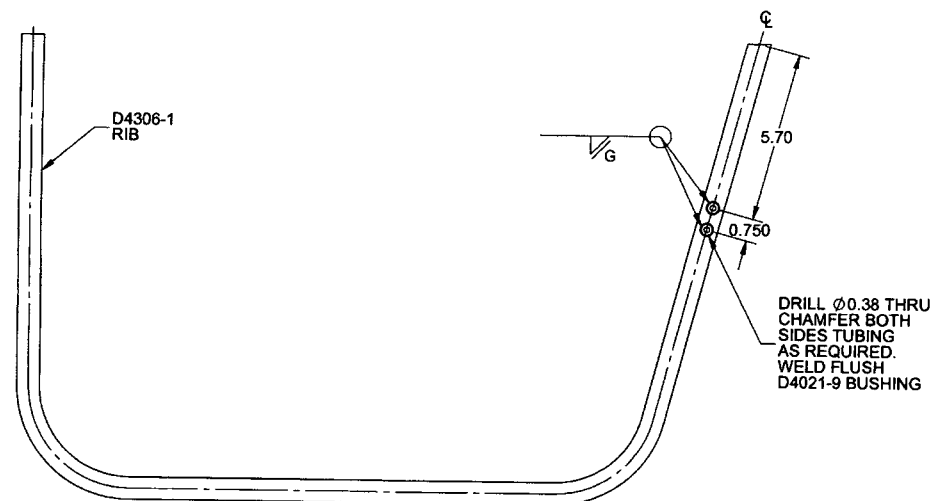
- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	JS	D4785	SHEET 6 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
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116181

RELEASED
2013-06-20
JW

ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4785	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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2013-06-20

4/11/6/18/